

What is claimed is:

1. A stack of siding, comprising:

a first coated siding piece comprising an outer topcoat layer, an inner decorative coating layer and a fiberboard cement substrate layer;

5 a second coated siding piece comprising an outer topcoat layer, an inner decorative coating layer and a fiberboard cement substrate layer; and

a liner positioned between the first coated siding piece and the second coated siding piece.

10 2. The stack of siding of claim 1, wherein during normal transportation and installation of the siding the siding retains an acceptable appearance that is substantially free of viewable scratches or mars.

3. The stack of siding of claim 1, wherein the siding is stacked in a face-to-face
15 pattern.

4. The stack of siding of claim 1, wherein the siding is stacked in a face-to-back pattern.

20 5. The stack of siding of claim 1, wherein the fiberboard cement substrate layer comprises wood pulp, silica and cement.

6. The stack of siding of claim 1, wherein the fiberboard cement substrate layer has a density of at least 1 g/cm³.

25

7. The stack of siding of claim 1, wherein the outer topcoat layer has a thickness of at least 8 microns.

8. The stack of siding of claim 1, wherein the outer topcoat layer has a thickness of at least 10 microns.

9. The stack of siding of claim 1, wherein the outer topcoat layer comprises a coating selected from the group consisting of polyurethane dispersions, acrylic emulsions, waterborne multi-component urethanes, waterborne multi-component epoxies, UV cured acrylics, visible light cured acrylics, and acrylic waterborne fluoropolymers.

10. The stack of siding of claim 1, wherein the outer topcoat layer comprises a polyurethane dispersion.

11. The stack of siding of claim 1, wherein the outer topcoat layer is cured by a process selected from the group consisting of: two-part curing mechanism, radiation curing, air drying and heat curing.

12. The stack of siding of claim 1, wherein the outer topcoat layer is cured at a board surface temperature less than 100 °C.

13. The stack of siding of claim 1, wherein the outer topcoat layer is cured at a board surface temperature less than 80 °C.

14. The stack of siding of claim 1, wherein the liner comprises a foam sheet.

15. The stack of siding of claim 1, wherein the siding piece exhibits at most a slight change in appearance after 20 double rubs with medium coarse #2 steel wool pad.

16. The stack of siding of claim 1, wherein the siding piece exhibits at most a minor change in appearance after 20 double rubs with medium coarse #2 steel wool pad.

5 17. A method of making a fiberboard cement siding product, comprising the steps of:

providing a fiberboard cement substrate layer;

coating a first major surface of the fiberboard cement substrate with a decorative coating;

10 coating the exposed surface of the decorative coating with a topcoat layer;
and

curing the topcoat layer to provide a mar and abrasion resistant siding.

18. The method of claim 17, wherein the curing step comprises a process that
15 does not expose the siding to a board surface temperature in excess of 100 °C.

19. The method of claim 17, wherein the fiberboard cement substrate layer has a
density of at least 1 g/cm³ and comprises wood pulp, silica and cement, the outer
topcoat layer comprises a polyurethane dispersion and has a thickness of at least 8
20 microns.

20. The method of claim 17, wherein the finished siding piece exhibits at most a
slight change in appearance after 20 double rubs with medium coarse #2 steel wool
pad.

25